

Work Order ID 156349

Friday, January 27, 2017 1:30:59 PM

156349

Page 1

Item ID: D3802-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Window Seal (\$ per foot)

Stop

NS2

Start Date: 1/24/2017 Start Qty: 25.00

Required Date: 1/27/2017 Req'd Qty: 25.00

25

DAS

Cust Item ID:

25

13

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: FEB 01 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3802

D

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 35220

Purchase Part Number: 93695K58

Supplier: Mc MASTER-CARR

Certificate of conformity is required

50

FEB 06 2017

DAS

13

9-89

110

0.00

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.08

Packaging

Ensure material certification is attached

50ft Sp17-02-13

120

0.00

120

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D3802

50

DAS

38

9-89

FEB 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 156349***156349***

Page 2

Friday, January 27, 2017 1:30:59 PM

Item ID: D3802-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window Seal (\$ per foot)
Start Date: 1/24/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: St41p	0.00							
130						50	6		FEB 14 2017
Packaging	Memo	0.04					9-89		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140							21		FEB 15 2017
QC	Memo	0.42					9-89		
Quality Control									

ME
17-2-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

Friday, January 27, 2017 1:31:02 PM

156349

D3802-1

Required Qty: 25.00

[illegible]

93695K58
WINDOW SEAL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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SPECIFICATION CONTROL DRAWING



D3802-X-YYY WINDOW SEAL
WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T THICKNESS	W WIDTH
D3802-1-YYY	McMASTER-CARR	93895K58	0.25	1.00

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-040
0.25" X 1.00" X 120" WINDOW SEAL = D3802-1-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156349 MJS
1702 el

RELEASED
2011-11-25

- NOTES:**
- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

D	CORRECTED P/N EXAMPLE FOR CUT LENGTH OF 40". ADDED EXAMPLE FOR CUT LENGTH OF 120" ZN 83-1). REASON: PART 11-100.	MB	11.11.22
C	CHANGE SUPPLIER P/N TO 93895K58 PER FLAMMABILITY TEST RESULTS	MB	10.08.30
B	CHANGE SUPPLIER P/N TO 93895K88 PER FLAMMABILITY TEST RESULTS	MB	08.12.16
A	NEW ISSUE	MB	08.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3802** REV. D
SHEET 1 OF 1
TITLE **WINDOW SEAL** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

DQA: _____ Date: _____



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OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35220**

Purchase Order Date 2/6/2017

PO Print Date 2/6/2017

Page Number 1 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FEB 06 2017

Contact Name
Vendor Phone 330 995 5500

Ship To Contact
Ship To Phone
Ship Via: Purolator ground ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	93695K58	WINDOW SEAL	2/9/2017 Yes 2/9/2017		50.00 f	\$0.32	\$16.15
	AS PER DWG D3802 REV. D B156349						
						Line Total:	\$16.15
2	71500-30	91732A212 HELICOIL	2/9/2017 Yes 2/9/2017		10.00 Each	\$4.17	\$41.70
						Line Total:	\$41.70
3	71400-20	7509A82 3M ADHESIVE 1300L	2/9/2017 Yes 2/9/2017		3.00 Each	\$49.28	\$147.84

Deliver To: JEAN-LUC

Note:

2/6/2017

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO35220

Page 1 of
02/06/2017

Order Placed By
Chantal Lavoie

McMaster-Carr Number
6693745-02

Line	Product	Ordered	Shipped
1	93695K58 Oil-Resistant Fire-Retardant Blended Buna-N Foam 50 Feet Adhesive-Back Strip, 1/4" Thick, 1" Wide	1 Each	1
2	91732A212 18-8 Stainless Steel Helical Insert, 1/4"-20 Right-Hand Thread, 3/8" Long, Packs of 10	10 Packs	10
3	7509A82 3M Gasketing Adhesive Number 1300L, 32-Ounce Can	3 Each	3
4	74825T25 Parts-Washing Brush for Delicate Materials 1-1/16" Brush Diameter, 2-1/4" Bristle Length	1 Each	1
5	7191T1 Parts-Washing Brush 0.018" Bristle Diameter, 1" Brush Diameter, 11" Overall Length	1 Each	1
6	8491A077 Press-Fit Drill Bushing 0.125" ID, 1/4" OD, 1/2" Long	6 Each	6

SP17-02-13

DAS
38
9-89

Shipped separately from our Chicago warehouse on 02/06

7	90261A164 Installation Tool for 3/8"-24 RH Threaded Helical Insert	2 Each	2
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Notes about your shipment

The U.S. Department of Transportation regulates the shipping of line 3. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.